

Work Order ID 71626

Page 1

Thursday, July 07, 2011 11:19:57 AM

Item ID: D3259-041

Accept



Setup Start



Revision ID:

Item Name: Access Panel Assembly

Stop



Start Date: 7/7/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-07-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3259	Rev B

100 Pick Kit

0.00



Packaging

Memo

0.00

Packaging

4

110



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Assemble D3259-041 as per Dwg D3259 . Note: Keep .040" Gap all around door.

6

120



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

49
49

Work Order ID 71626

Page 2

Thursday, July 07, 2011 11:19:57 AM

Item ID: D3259-041

Accept



Setup Start



Revision ID:

Item Name: Access Panel Assembly

Stop



Start Date: 7/7/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

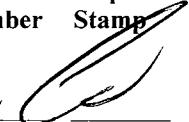
130

Identify as per dwg & Stock Location: 85182 - 0.00

Packaging

Memo

4X

8011-09-20

140



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/09/21MF
11-09-20

Picklist Print

Page 1

Thursday, July 07, 2011 11:19:50 AM

Work Order ID: 71626



Parent Item: D3259-041



Parent Item Name: Access Panel Assembly

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

IPP REV

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-5 		Manufactured	No			110	Each	14.0000	1			B711/09/20	

Hinge 9.9"

D3259-1

Panel

D3259-3

Doubler

D3259-5

Spacer

Location	Loc Qty	Loc Code
ST037	14	
47187	2	
47773	12	

Location	Loc Qty	Loc Code
ST180	1	
60082	1	

Location	Loc Qty	Loc Code
ST180	1	
60083	1	

Location	Loc Qty	Loc Code
ST180	3	
60084	3	

Required Date: 7/21/2011
Required Qty: 4.00

Required Qty: 4.00

B711/09/20

 2
2 4
B711/09/20

B71630 (3x)

 4
B711/09/20

B71628 (3x)

 4
B711/09/20

B71629 (1x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Thursday, July 07, 2011 11:19:51 AM

Work Order ID: 71626



Parent Item: D3259-041



Parent Item Name: Access Panel Assembly

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

D3259-7



Door

Manufactured

No

110

Each

1.0000

1

4



JS 11/09/20

B71632 (3x)

Location

ST180

Loc Qty

1

Loc Code

1

D3260-1



Spring

Manufactured

No

110

Each

0.0000

2

8



JS 11/09/20

D3973-5



Receptable, Rigid, DZUS

Manufactured

No

110

Each

68.0000

2

8



JS 11/09/20

D3974-20



Stud, Wing Head, 5/16 DZUS

Manufactured

No

110

Each

91.0000

2

8



JS 11/09/20

MS20426AD4-4



Rivet

Purchased

No

110

Each

2,452.000

4

16



JS 11/09/20

16

Location

ST103

Loc Qty

91

Loc Code

8

58761

66

61160

25

116188

2452

2452

Picklist Print

Page 3

Thursday, July 07, 2011 11:19:53 AM

Work Order ID: 71626



Parent Item: D3259-041



Parent Item Name: Access Panel Assembly

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

MS20470AD3-4



Purchased

No

110

Each

9,156.000

36

144



Rivet,Universal Head

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST319	9156	
111477	8332	
15541	824	

MS20470AD3-5



Purchased

No

110

Each

3,892.000

10

40



Rivet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST319	3892	
104817	3030	
9682	862	

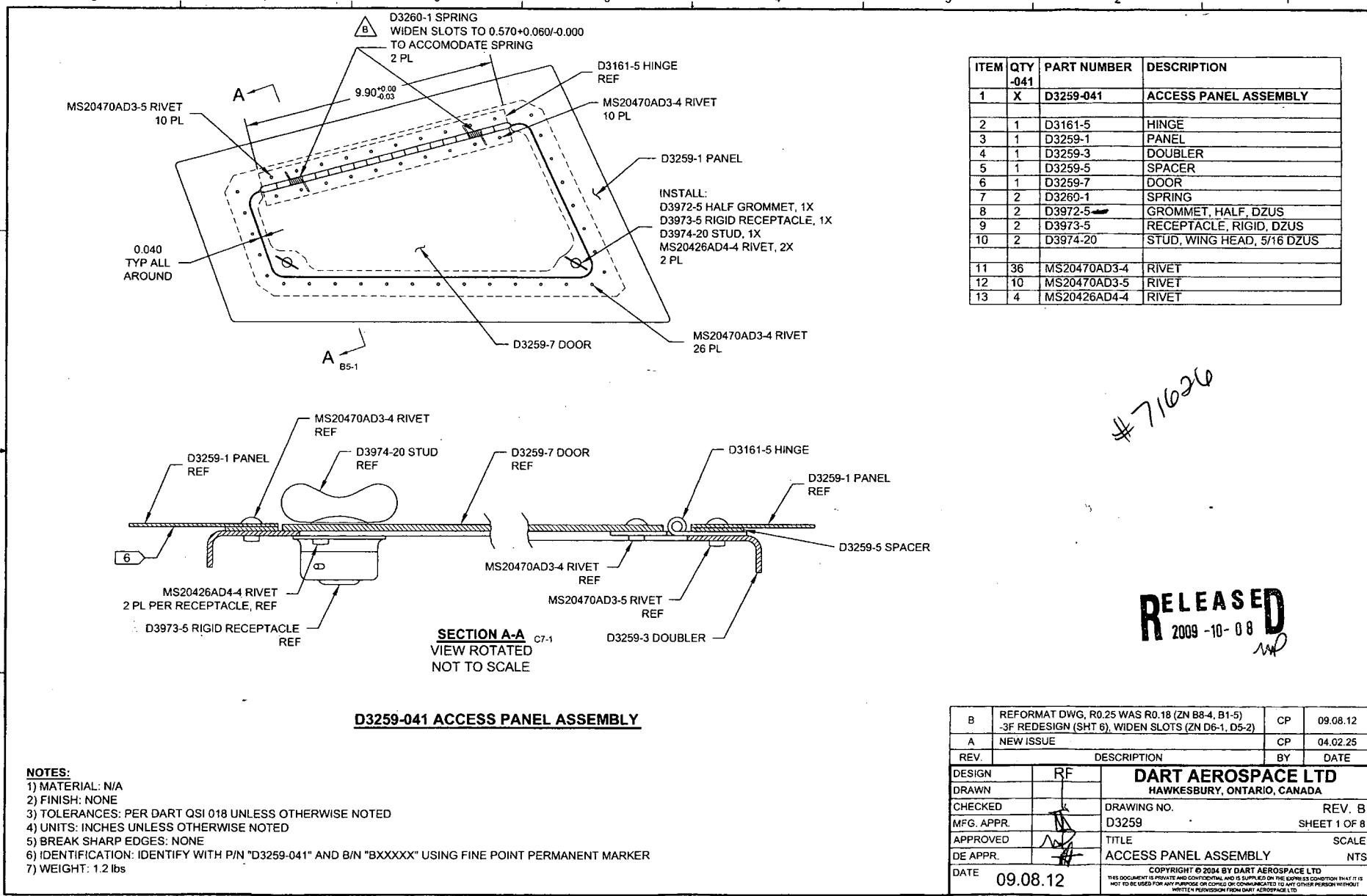
~~MS20470AD3-4~~ 11.09.20

~~MS20470AD3-5~~ 13972-5

272

B: 1115178

SP 11/09/20



B REFORMAT DWG. R0.25 WAS R0.18 (ZN B8-4, B1-5)
-3F REDESIGN (SHT 6), WIDEN SLOTS (ZN D6-1, D5-2) CP 09.08.12

A NEW ISSUE CP 04.02.25

REV. DATE

REV. DESCRIPTION

REV.	DESCRIPTION	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D3259 SHEET 1 OF 8
APPROVED		TITLE SCALE
DE APPR.		ACCESS PANEL ASSEMBLY NTS
DATE	09.08.12	

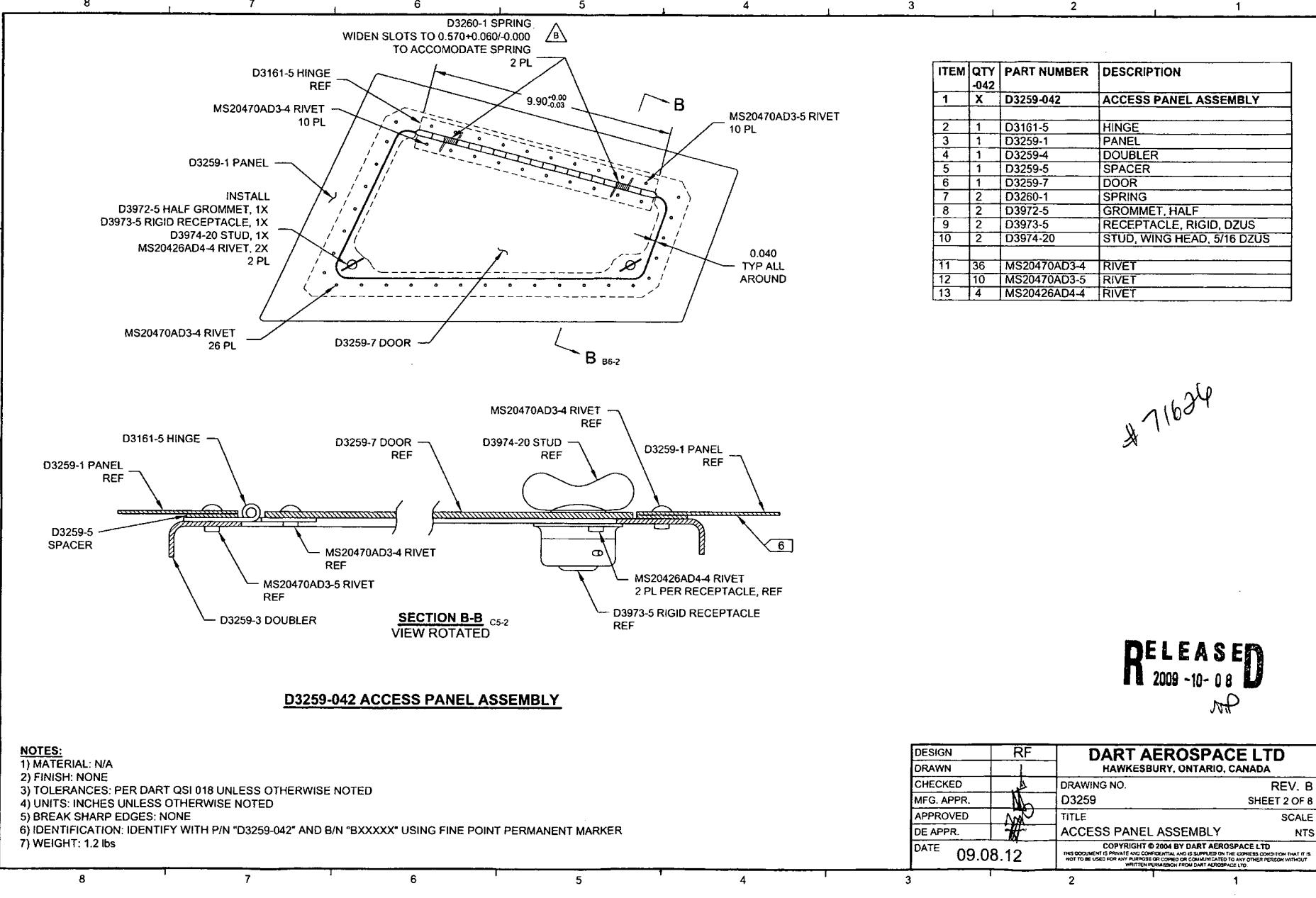
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

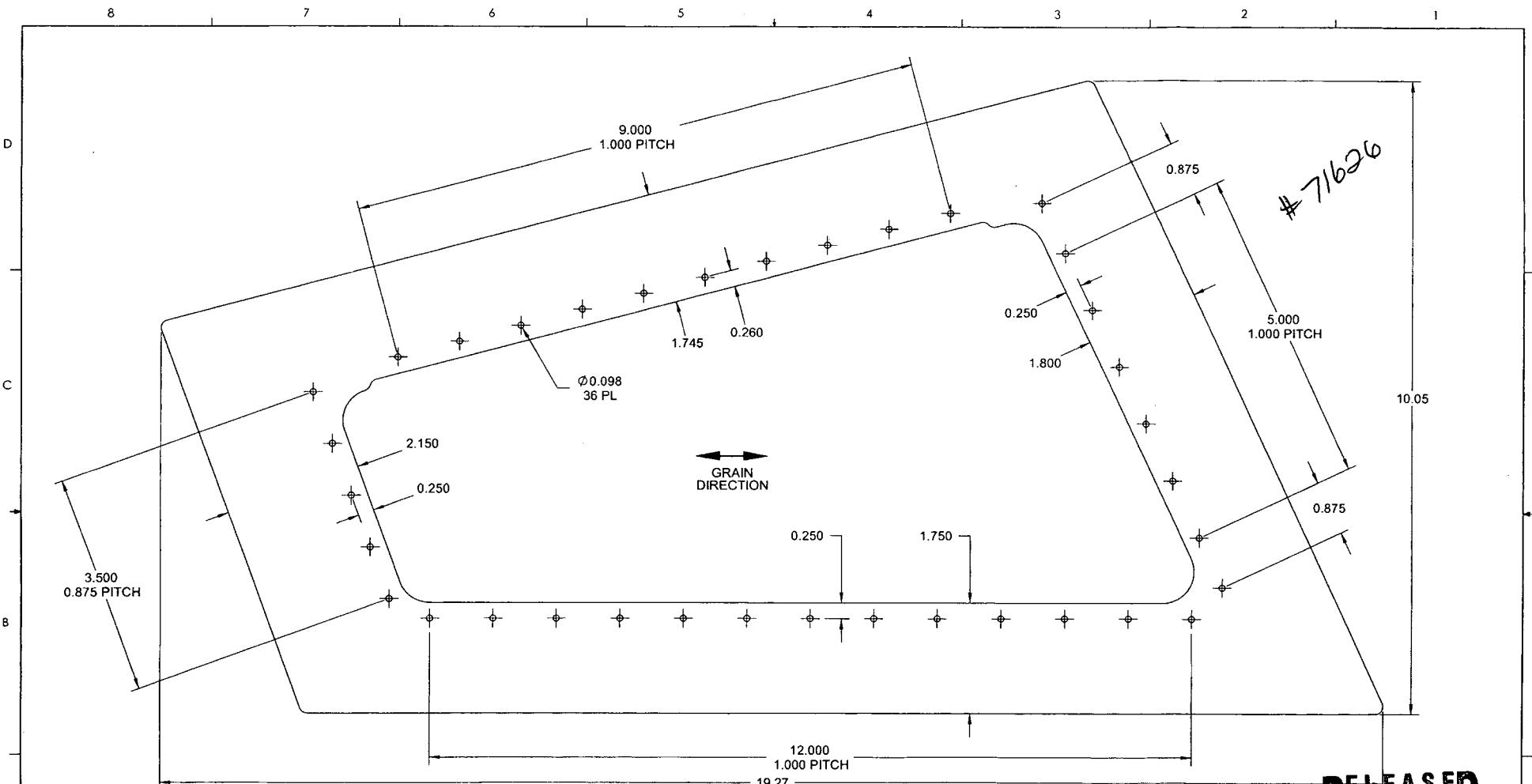


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NOTE: Date & initial all entries



D3259-1 PANEL

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.25 lbs
- 8) MAKE PER DWG FILE "D3259-1B.DXF"

RELEASED
2009-10-08
NYC

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKSLEY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	D3259
APPROVED	<i>[Signature]</i>	REV. B
DE APPR.	<i>[Signature]</i>	SHEET 3 OF 8
DATE	09.08.12	SCALE NTS

ACCESS PANEL ASSEMBLY

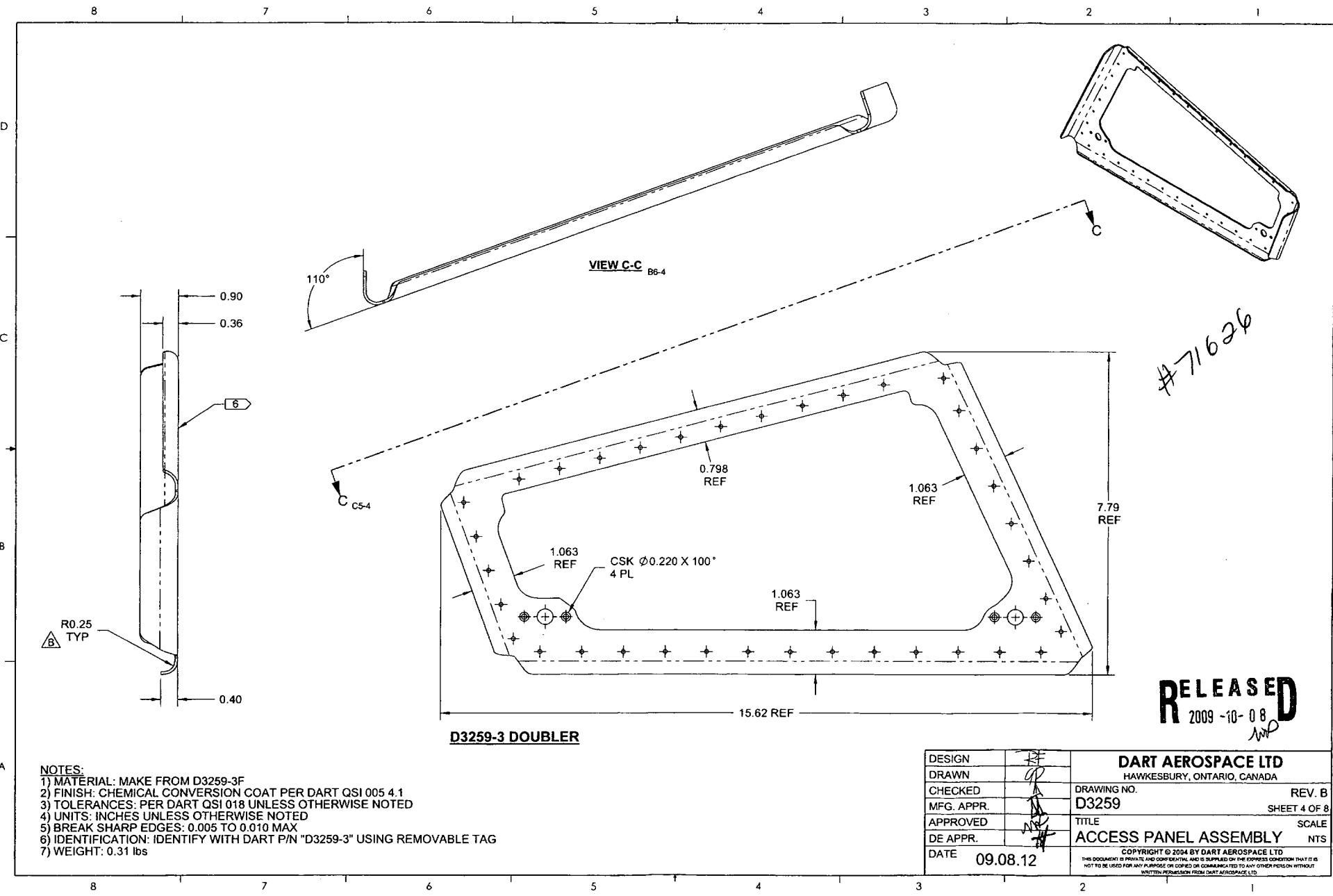
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



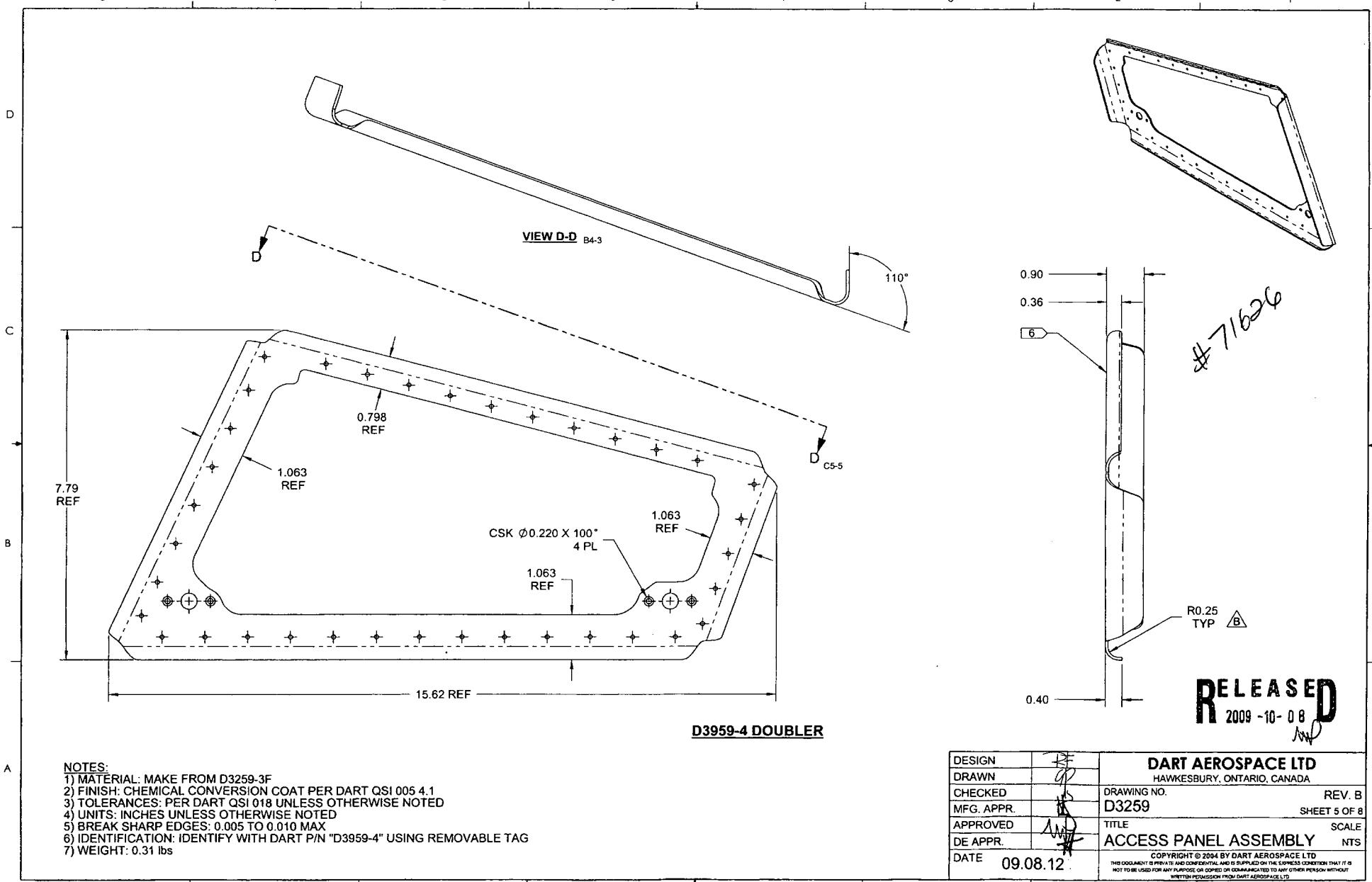
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



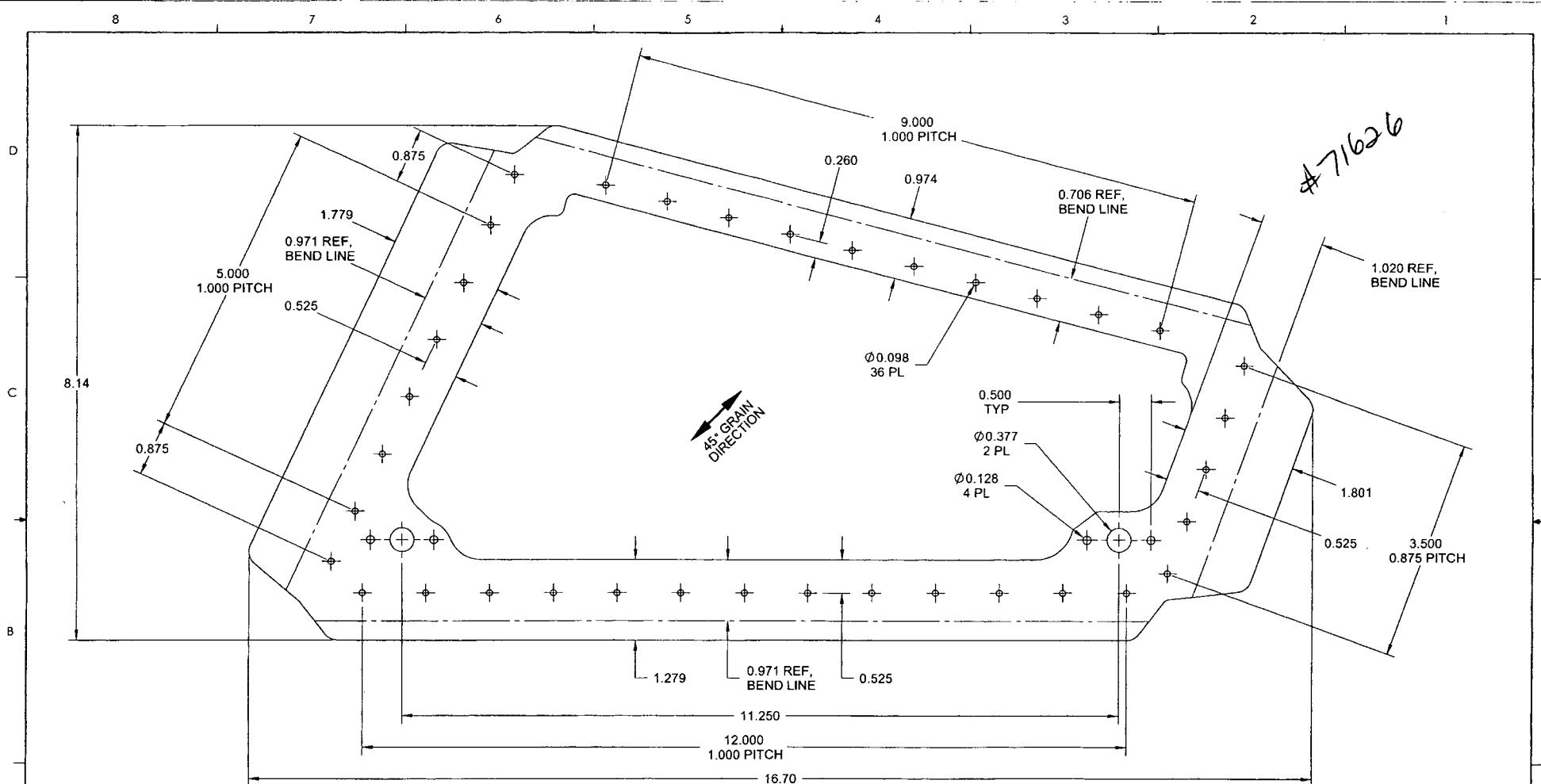
8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3259-3F DOUBLER

RELEASED
2009-10-08

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.063

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-3F" USING REMOVABLE TAG

7) WEIGHT: 0.31 lbs

8) MAKE PER DWG FILE "D3259-3FB.DXF"

DESIGN	<u>DP</u>	DART AEROSPACE LTD	
DRAWN	<u>DP</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>S</u>	DRAWING NO.	REV. B
MFG. APPR.	<u>TD</u>	D3259	SHEET 6 OF 8
APPROVED	<u>JAD</u>	TITLE	SCALE
DE APPR.	<u> </u>	ACCESS PANEL ASSEMBLY	
DATE	09.08.12	NTS	

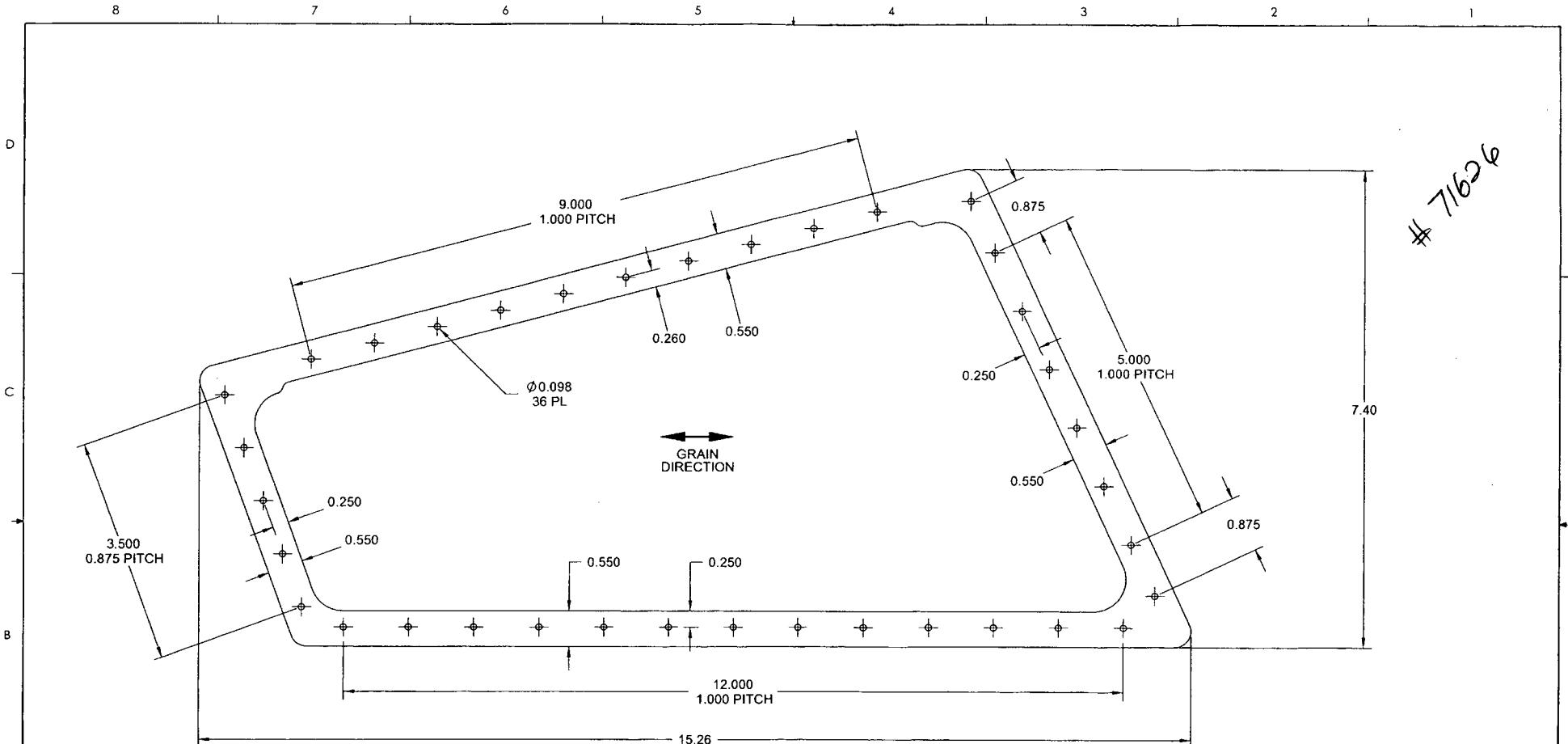
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3259-5 SPACER

RELEASED
2009-10-08
[Handwritten Signature]

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.032
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-5" USING REMOVABLE TAG
 - 7) WEIGHT: 0.07 lbs
 - 8) MAKE PER DWG FILE "D3259-5B.DXF"

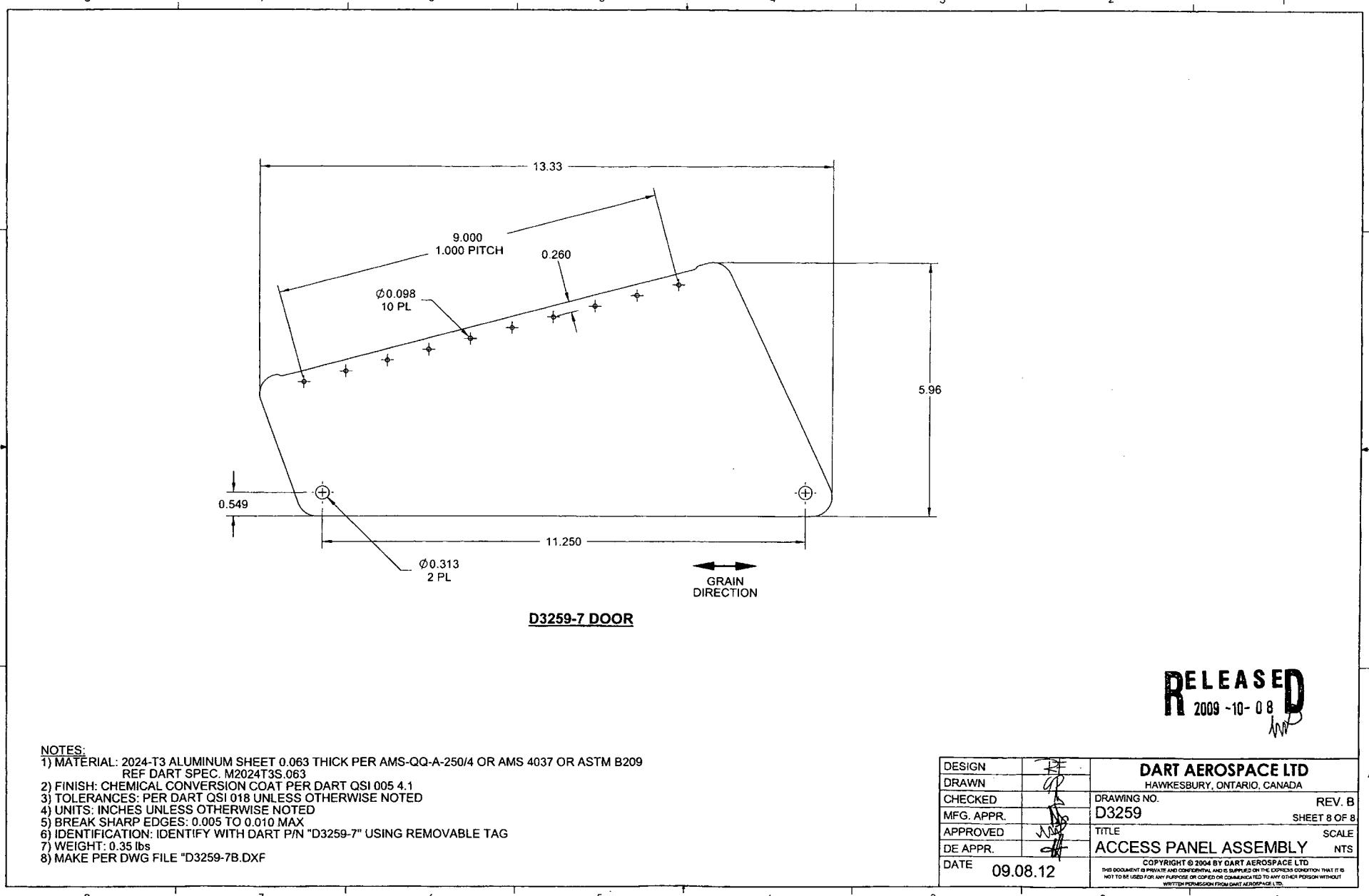
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DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA			
CHECKED	<i>[Signature]</i>	DRAWING NO.			
MFG. APPR.	<i>[Signature]</i>	REV. B			
APPROVED	<i>[Signature]</i>	D3259			
DE APPR.	<i>[Signature]</i>	SHEET 7 OF 8			
DATE	09.08.12	TITLE ACCESS PANEL ASSEMBLY			
SCALE NTS					
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries



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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries